

5/05

DART AEROSPACE LTD	Work Order:	22233
Description: Bushing	Part Number:	D2806-1
Dwg: D2806 rev. A	Qty:	20

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Issue W/O	df	05.01.11	20
2	METAL	Cut blanks: 1.100" long -0.010" +0.030" Material: 6061-T6 (QQ-A-200/8) or (QQ-A-250/11) 1.0" Hex stock			
3	HAAS	Machine as per folio FA105	m9075 Batch: 110161	05.02.28	20
4	QC	Inspect Level 2		05.02.28	20
5	QC	Inspect Level 8	PC	05.03.02	20
6	METAL	Tumble & Deburr		05.03.02	20
7	QC	Inspect Level 5	PC	05.03.02	20
8	FINISHING	Chemical conversion coat per QSI 0051 Acid etch & Iodine	00.11.13 00.11.13	05.03.03	20
9	STORES	Identify and stock	11	05.03.04	20
10	EXPEDITING	Close W/O Cost / part: 1.05 Sac 05/03/08 (20) 1.53	df	05.03.09	20

Rev	Date	Change	Revised By	Approved
A	00.11.13	New Issue	EC	df

RELEASED

00.11.13

UNDER REVIEW

02.06.22/df

CANCEL 04.01.19

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector		
			Initial Design Mgr	Action Description Design Mgr	Sign & Date					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	22239
Description: Bushing	Part Number:	D2806-1
Inspection Dwg: D2806	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	05.02.28	Date:	65.03.02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	RF

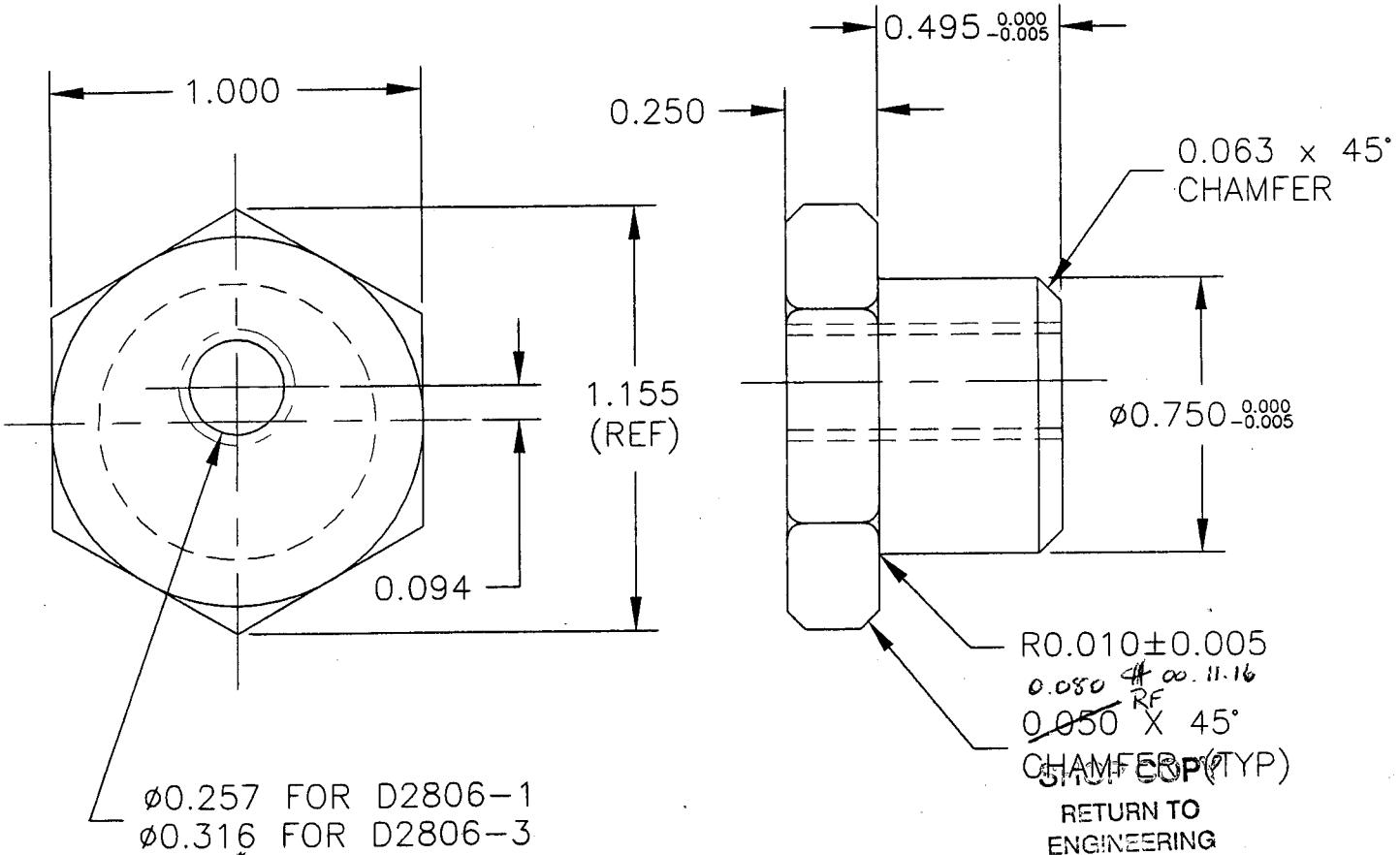
RELEASED

H:\FORMS\Quality Assurance\approved QA\FAI revD



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D2806	SHEET 1 OF 1
DATE		TITLE	SCALE
00.11.08		BUSHING	2:1
A	00.11.08	NEW ISSUE	

RELEASED
00.11.13



D2806-1 (DRILL Ø0.257 HOLE)
D2806-3 (DRILL Ø0.316 HOLE)

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 22239

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ST = 2.629
R = 610
FIN = 2.775
Z = 444

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 17, 2005
10:23 am

Work Order No : 0022239
 Project Name : D2806-1
 Project For : WK505
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2806-1
 Description : Bushing
 Manufactured : Yes
 Amount Req'd : 20
 Amount Done : 0
 Start Date : 01-17-05
 Est Finish Date : 01-24-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
===== ===== =====					
Burden :	0.00	0.00	0.00		
===== ===== =====					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00